

Date: Monday, 12/05/2008 9:58:07 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 EXTRUSION BENDING
Job Number :	39178		
Estimate Number :	10311		
P.O. Number :		Part Number :	D2620
This Issue :	12/05/2008	Drawing Number :	D2620 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	B
Previous Run :	39154	Material :	
Written By :		Due Date :	25/05/2008
Checked & Approved By :	JUD 08-5-12		
Comment :	Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	34715 ^{x9} / 24508 ^{x11}

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

AWM / RT
 8-5-12 (20)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

08/05/13 (20)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: skid tube cell

RT 08-05-13 (20)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

08/05/14

Job Completion



u 8-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

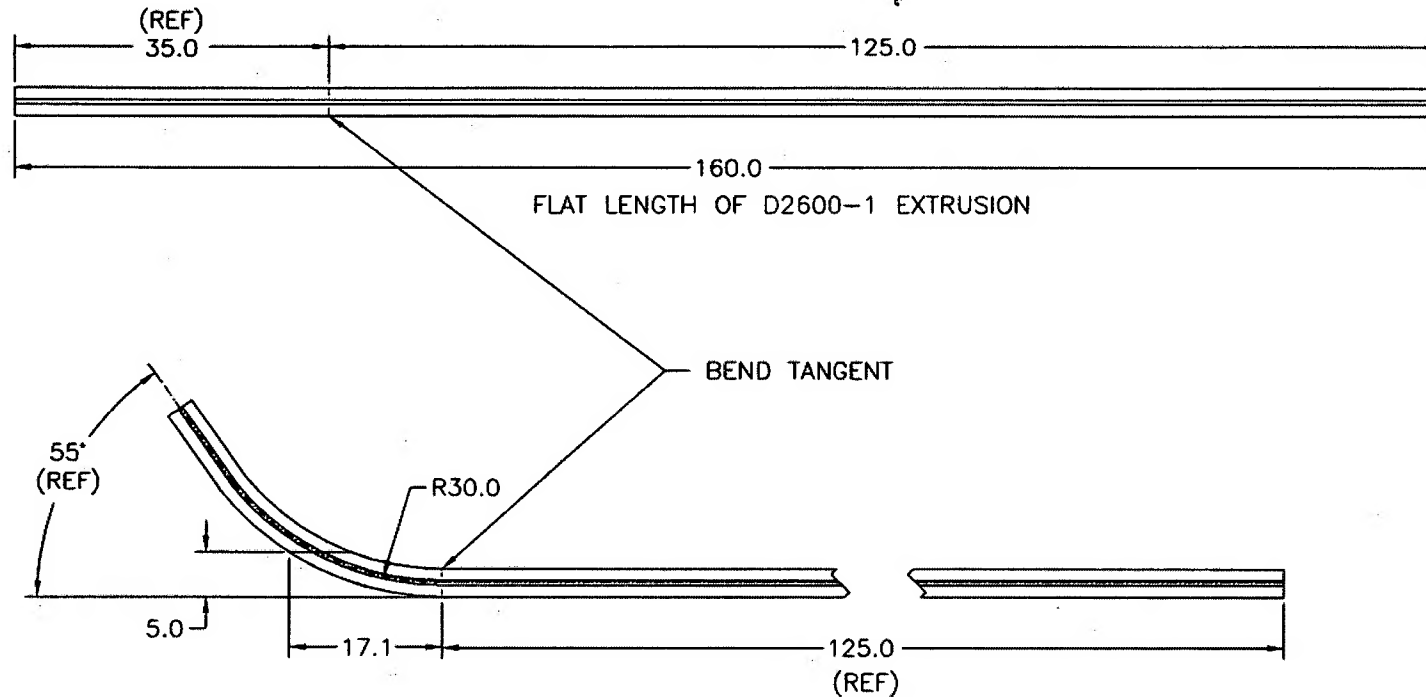
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED	KE	APPROVED	KE	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	DRAWING NO.	D2620	REV. B
		TITLE	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
				SCALE 1:20
A	97.11.07	NEW ISSUE		
B	97.09.10	UPDATE FOR IN-HOUSE BENDING		

RELEASED
49.04.15 DS